

Work Order ID 134088

Monday, June 29, 2015 9:59:21 AM

134088

Page 1

Item ID: D3566-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Gasket Aft / Fwd

Start Date: 6/29/2015 Start Qty: 6.00 *6* Cust Item ID:

Required Date: 6/29/2015 Req'd Qty: 6.00 *6* Customer:

Reference:

Approvals: Process Plan: ML Date: JUN 29 2015 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3566	Rev C

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg D3566 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

BAS
38
9-89
JUL 17 2015

Work Order ID 134088

Monday, June 29, 2015 9:59:21 AM

134088

Page 2

Item ID: D3566-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gasket Aft / Fwd
Start Date: 6/29/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/29/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MLJ JUL 02 2015

MLJ JUL 02 2015

Picklist Print

Monday, June 29, 2015 9:59:25 AM

Page 1

Work Order ID: 134088

134088

Parent Item: D3566-1

D3566-1

Parent Item Name: Gasket Aft / Fwd

Start Date: 6/29/2015

Required Date: 6/29/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

288.4000

0.911

7

MNEO60S 063

NEOPRENE SHEET 0.063

06/15/06/30

Location

Loc Qty

Loc Code

MAT052

288.4

M130840

28.2

M131990

260.2

7.4

DART AEROSPACE LTD		Work Order: 134088
Description: Gasket		Part Number: D3566-1
Inspection Dwg: D3566	Rev: C	Page 1 of 1

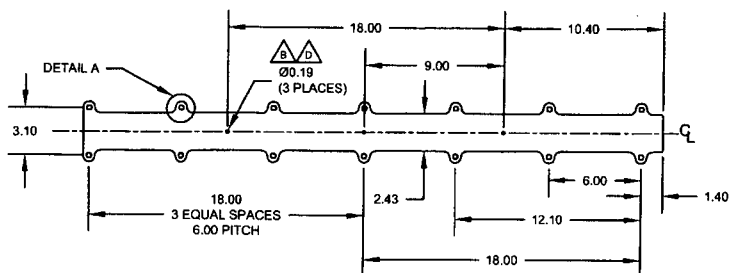
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

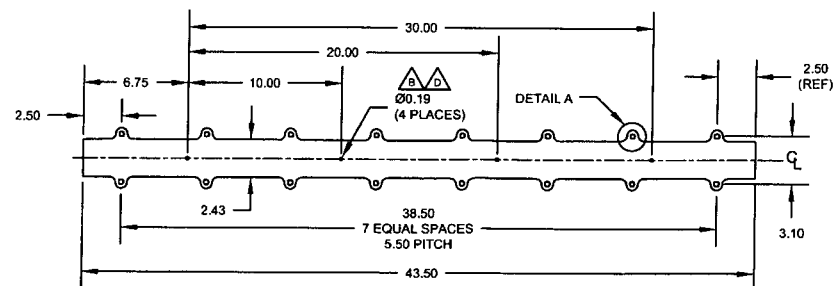
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.104	/		Tape	
18.00	+/-0.030	18.00	/		U-Dx-02	
12.10	+/-0.030	12.10	/			
2.43	+/-0.030	2.43	/			
6.00	+/-0.030	6.00	/			
1.40	+/-0.030	1.40	/			
0.30	+/-0.030	.305	/			
0.30	+/-0.030	.305	/			
0.063	+/-0.010	.062	/			
Ø0.188	+0.005/-0.001	Ø .191	/			

Measured by: DK	Audited by: DAS 38 9-89	Prototype Approval:	N/A
Date: 15/06/30	Date: 11/11/07 2015	Date:	N/A

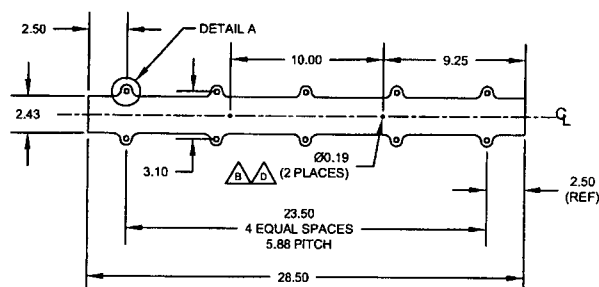
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	CE



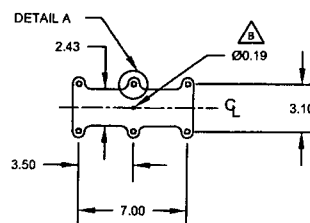
D3566-1 GASKET



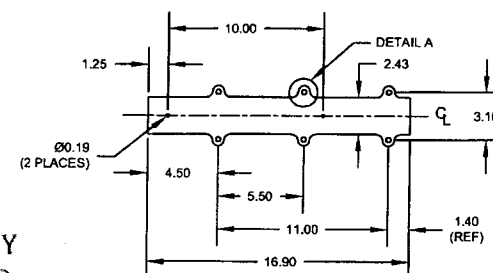
D3566-5 GASKET



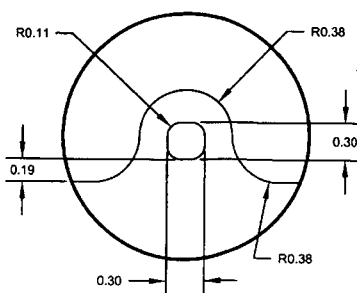
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



**DETAIL A
SCALE 1:1**

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 134088
MLJ
150629

RELEASED

07.08.04

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE TABLE IN ZONE A3
 - 8) PARTS ARE SYMMETRIC ABOUT ϕ

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3566 TITLE GASKET REV. C SHEET 1 OF 1 SCALE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			